

Work Order ID 141158

141158

January 28, 2016 4:10:30 PM

Ship March 9/16

Page 1

Item ID: D206-642-312BL Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH, Low & High Gear (Ael Blue)
 Start Date: 1/28/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/9/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SU 20160128 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q							ML5 16-02-01	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-312 CHG008								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

B141147

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D206-642-312BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH, Low & High Gear (Ael Blue)
 Start Date: 1/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/9/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MAS
27
9-00

MAR 1 0 2016

MAR 1 0 2016

MCS

SJA 20160310

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 141158

141158

Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:
 IPP Rev: J 05.10.11 Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP
 Rev: M 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC IPP Rev: P 14.04.25
 ECN14-520 DD verf: JLM IPP REV: Q 15.10.09 ADDED
 BL DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341BL

Manufactured No

Each 2.0000

1

***D206-642-341RI ***

Replacement Skidtube (Fits LH or RH)

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

140301

1

140305

1

B141147

D206-648-013BL

Manufactured No

Each 0.0000

1

***D206-648-013RI ***

Ground Handling Wheel Modification

140314 SP

D2932-2BL

Manufactured No

110

Each 1.0000

1

1

***D2932-2RI ***

Saddle RH Out, 206

141000

DAS
28
9-89

Location

Loc Qty

Loc Code

ST392

1

138658

1

D2933-2BL

Manufactured No

110

Each 3.0000

1

1

***D2933-2RI ***

Saddle RH In, 206

141092

MAR 08 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST389

3

138660

3

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Work Order ID: 141158

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Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2938-2BL

Manufactured No

110 Each

3.0000

1 1

***D2938-2RI ***

Saddle RH Out, 206

DAS
28
9-89

**

141070

DAS
6
9-89

MAR 08 2016
27
9-89

Location

Loc Qty

Loc Code

ST390

3

138659

3

D2939-2BL

Manufactured No

110 Each

2.0000

1 1

***D2939-2RI ***

Saddle RH In, 206

DAS
28
9-89

**

141029

MAR 08 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST391

2

139953

2

AN3-41A

Purchased No

110 Each

466.0000

8 8

AN3-41A

Bolt

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

20

122416

20

over003

314

123355

314

ST347

132

123355

132

D2652

Manufactured No

110 Each

439.0000

16 16

D2652

Bushing

DAS
28
9-89

**

FEB 04 2016

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

394

136228

387

136792

7

16x.

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Shop Packet Print

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Work Order ID: 141158

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Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,544.000

8

8

MS21042L3

Nut

DAS
26
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

186

m133790

186

8k

NAS1149D0363J

Purchased

No

110

Each

1,858.000

8

8

NAS1149D0363J

Washer

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

84

m130799

84

ST260a

1000

m134055

1000

ST263

774

m133790

274

m133932

500

8x

DAS
28
9-89

FEB 02 2016

Picklist Print

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Work Order ID: 141158

141158

Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

322.0000

4

4

AN5-10A

Bolt

68-6
26
27
9-89
DAS

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

over003

200

m133769

50

m134039

150

ST338

71

m133483

71

4x

AN5-11A

Purchased

No

110

Each

109.0000

4

4

AN5-11A

BOLT

68-6
26
27
9-89
DAS

Location

Loc Qty

Loc Code

over003

50

M134039

50

ST338

59

M133077

9

M133234

50

4x

DAS
28
9-89

FEB 02 2016

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Work Order ID: 141158

141158

Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,410.000

8

8

NAS1149D0563.J

Washer

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

354

m133363

154

m133938

200

ST269

103

m128257

103

8k

AN4-6A

Purchased

No

110

Each

1,185.000

12

12

AN4-6A

BOLT

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

over03

1000

M133790

1000

ST345

42

M133316

18

M133363

24

12x

FEB 02 2016

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Work Order ID: 141158

141158

Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

5,435.000

24

24

NAS1149D0463.J

WASHER

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST260a

2000

M134039

2000

ST263

1689

M134039

1689

ST269

1349

M130799

361

M132317

100

M132677

888

24x

MS21042L4

Purchased

No

110

Each

3,356.000

12

12

MS21042L 4

Locknut

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST007

1500

m134055

1500

ST303

1692

m133769

1692

ST305

97

m130922

97

12x

FEB 02 2016

Picklist Print

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Work Order ID: 141158

141158

Parent Item: D206-642-312BL

***D206-642-312BI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

12.0000

1

D3407-043

Tow Ring

**

①

B140316

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st530

12

136685

10

136686

2

BLUE

D3456-1

Manufactured No

110 Each

125.0000

1

1

D3456-1

Washer

**

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

118

136922

43

140756

75

LK

D3457-1

Manufactured No

110 Each

66.0000

2

2

D3457-1

Washer

**

DAS
26
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST037

8

127393

8

ST038

4

136442

4

ST038A

44

138904

44

2x

FEB 01 2016

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Work Order ID: 141158

141158

Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,034.000

1

1

MS21043-4

Nut

DAS
26
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	262	
m132803	262	
ST302	10	
m133316	10	
ST32	722	
m133769	722	

AN4C5A

Purchased

No

110

Each

80.0000

1

1

AN4C5A

Bolt

DAS
26
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER002	50	
m133990	50	
ST345	30	
m132857	10	
m133135	20	

NAS1149C0463R

Purchased

No

110

Each

212.0000

1

1

NAS1149C0463R

Washer

DAS
26
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001	72	
m127306	72	
ST271	140	
m128401	40	
m133077	100	

FEB 01 2016

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Work Order ID: 141158

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Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

21.0000 1

D3413-1

O-Ring

**

①

B141552

DAS 26 27 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st530

21

136462

21

BLUE

D2712

Manufactured No

110 Each

433.0000 10 10

D2712

Set Screw

**

DAS 26 27 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

278

102226

12

135950

242

89929

10

93686

14

ST012a

100

140532

100

D2934

Manufactured No

110 Each

42.0000 2 2

D2934

Saddle Spacer

**

DAS 26 27 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

36

136116

36

FEB 01 2016

2x

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Work Order ID: 141158

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Parent Item: D206-642-312BL

***D206-642-312BI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

30.0000

2

2

D2935

Saddle Spacer

DAS
26
9-89
27
9-89

FEB 01 2016

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

24

136244

24

DAS
28
9-89

DAS
28
9-89

2x

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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